

Work Order ID 88061***88061***

Page 1

Tuesday, July 24, 2012 11:16:52 AM

Item ID: PB67-43001-209

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Square Tube

NS2

Start Date: 7/24/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MFDate: 12-07-27

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut to length as per dwg
2- make a chamfer on both ends of tube
3- deburr

1 ϕ Ag
12-07-27

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS
16
12/7/30

1 ϕ Ag
12-07-30

120

Identify as per dwg & Stock Location: MM4

0.00

120

Packaging

Memo

0.00

Packaging

1 ϕ Ag
12-07-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
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Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
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Work Order ID 88061***88061***

Page 2

Tuesday, July 24, 2012 11:16:52 AM

Item ID: PB67-43001-209

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Square Tube

Stop ***NS2***Start Date: 7/24/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/27/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/8/11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, July 24, 2012 11:16:52 AM

Page 1

Work Order ID: 88061
Parent Item: PB67-43001-209
Parent Item Name: Square Tube

Start Date: 7/24/2012 Required Date: 7/27/2012
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6TS1.000W.065

6061T6 SQ TUBE 1.00 x 1.00 X 0.065w

Purchased

No

100

f

0.0000

0.8542

0.8991579

BA# M110680

0.8991579 → A₀
12.07.27.

B/N?

NCR: Yes / No

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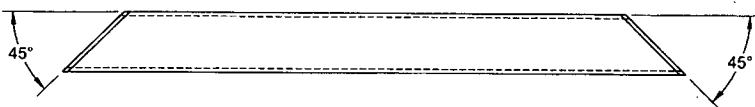
8 7 6 5 4 3 2 1

D

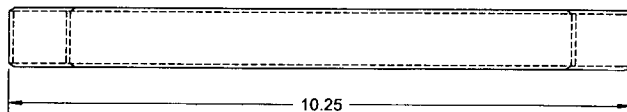
C

B

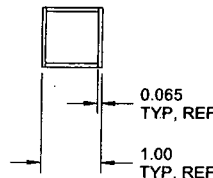
A



0.06 X 45° CHAMFER
4 PL

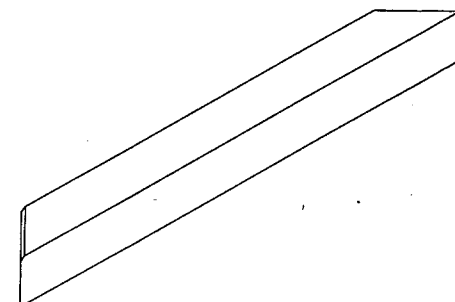


10.25



0.065
TYP, REF

1.00
TYP, REF



D

C

B

A

B67-43001-209 SQUARE TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

RELEASED
2009-09-24
MB

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 17 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-209 TITLE SQUARE TUBE COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. C	
DRAWN			SHEET 1 OF 1	
CHECKED	AS		SCALE	
MFG. APPR.	JS		NTS	
APPROVED	MB		DATE	
DE APPR.	N/A		09.02.19	
DATE	09.02.19			

8 7 6 5 4 3 2 1

NCR: Yes / No

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